

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027282**Date Inspected:** 06-Mar-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Westmont Industries**Location:** Santa Fe Springs. Ca

CWI Name:	Chris Concha		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** SAS Travelers**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the Westmont Industries (WMI) job site in Santa Fe Springs, California between the times noted above in order to monitor fabrication and the Quality Control functions for the SAS Superstructure, Bid Item #99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path). The following items were observed:

Navigation Light Mounts

This QA Inspector randomly observed WMI welder Daniel Grayum (ID3049) tack weld the 1" x 12" threaded studs to 150mm x 170mm x 6mm plates on the navigation light mounts for the SAS Travelers. QC Inspector Christopher Concha was observed performing the fit-up operations and monitoring the welding. The welder was observed performing the FCAW process to tack the studs in place and weld the complete penetration joint (CJP). This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was completed on this date.

SAS Traveler-West Bound

This QA Inspector was informed by RPI Coating's Mr. Preston Keen that RPI will be blasting the pipe mounting brackets and apply zinc coating on the SAS Traveler-WB. The parts were observed after blasting for uniformity and complete area coverage. Upon completion of the blasting, Mr. Keen performed three (3) random surface profile tests utilizing extra course (XC) film strips. This QA Inspector observed an average reading of 2.7 mils. (Acceptable range; 1.5mils-3.4mils) Mr. Keen was observed performing a soluble salts test and this QA

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Inspector observed a reading of 0. Environmental readings were obtained and recorded prior to and upon completion of coating. The areas will cure for 72 hours. The following batch numbers are for the zinc coating applied.

Part A-XM1611FB

Part B-XM2341JX

Part F-0761

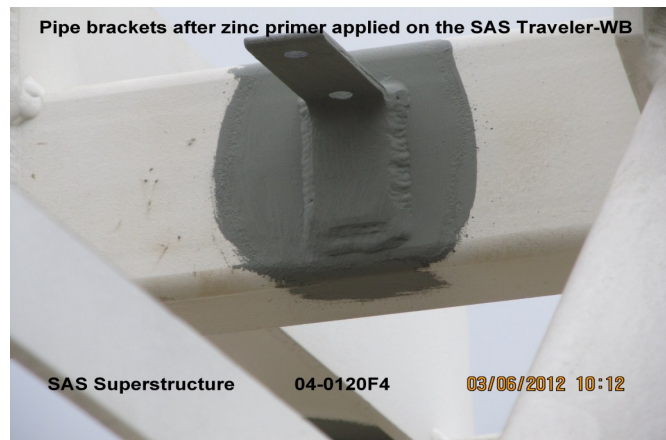
3/8" galvanized pipe Zemarc Corporation Los Angeles CA

This QA Inspector reviewed the contractor's shipping list. This QA Inspector also made random observations of the material as it was presented. This QA Inspector noted that the material and documentation appeared to be in general compliance with the contract requirements. This QA Inspector issued a green tag with Caltrans QA lot number B335-002-12 for bid item #99 Maintenance Travelers.

This QA noted above items observed appear to comply with the contract documents.

Summary of Conversations:

As noted above.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910 , who represents the Office of Structural Materials for your project.

Inspected By:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
